



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3507-1-BENT Job Sheet 192040



Part No: D3507-1-BENT

Job Qty: 2 pcs

Part Name: Skidtube Assembly EC135



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP rev A 10.09.17 new issue EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - Bend - 1	2 pcs	4/2/19	4/2/19	0.33	1.18	Skidtubes - Bend		MKG
140	QC 5	2 pcs	4/2/19	4/2/19	0.00	0.00	QC 5 - 10		BE
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
300	Packaging 3-1 - Stock - B4B	2 pcs	4/2/19	4/2/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S166847



Part: D3507-1-BENT

Job No: 192040

Serial No/Batch: S166847

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/27/19

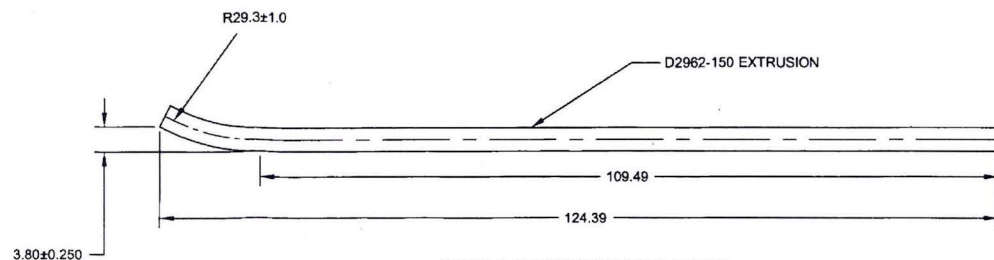
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
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				Packaging 3 - 18 - B4B	BE	
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
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				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
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				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
310	QC 21 - SA	2 pcs	4/2/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	MAR 28 2019 21
					QC 21 - SA - 53	9-26
Part Op 120 - (CNC Delta 100 Bender), 1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507, use Descriptions: DT9632 bending aide 2- Cut FWD END of tube as per dwg D3507 140 - (QC5- Inspect part completeness to step on W/O) 300 - (Identify as per dwg & Stock Location: <u>LG002</u>), LOCATION : LG002 310 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D2962-150	3.540 Outer Tube, Extrud	2 pcs (1 ea)	120-Skidtubes - Bend - 1	5084714		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
120-Skidtubes - Bend - 1	D2962-150	2	35	0		
Part Specifications						
Specifications could not be found.						

Plex 3/14/19 1:36 PM Dart.lajeunesse.marie

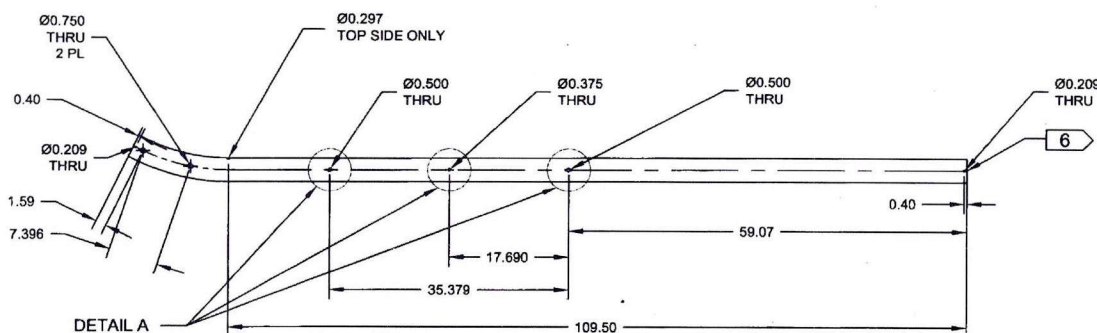
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2982-150	EXTRUSION
1	D2985	CAP
1	D2985-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20801AD4W3	RIVET

GENERAL NOTES:

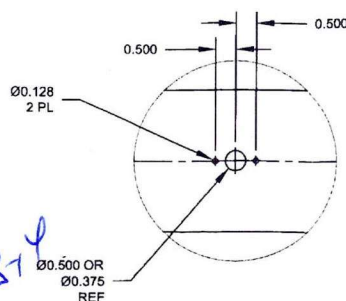
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL

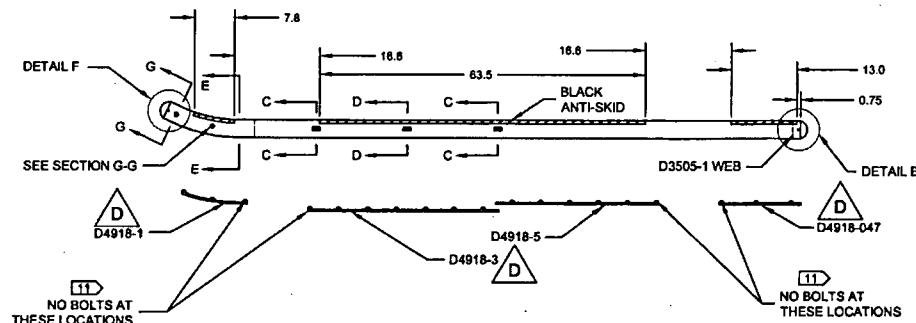
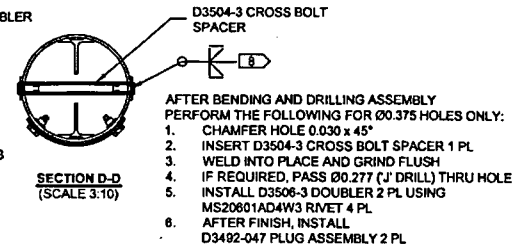
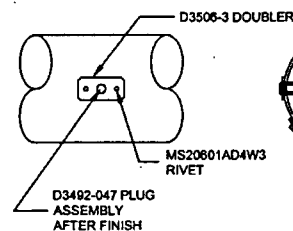
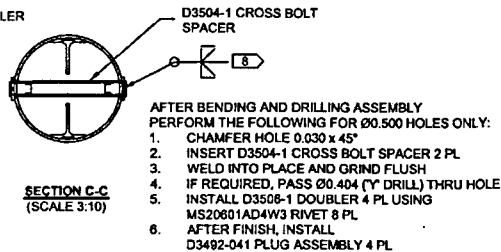
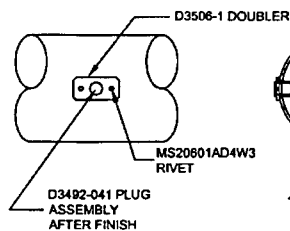


DETAIL A

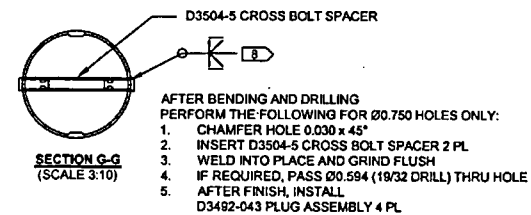
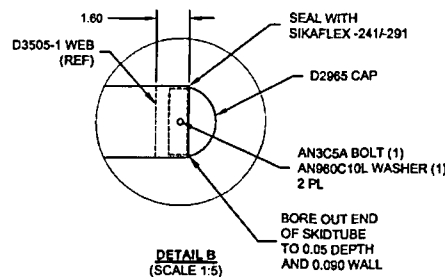
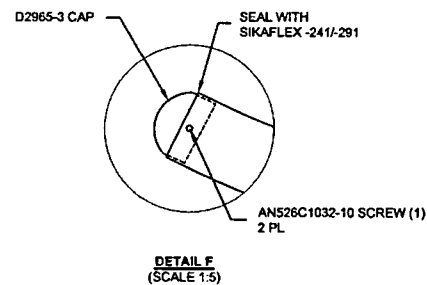
TYP, 6 PL
SCALE 3:10

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192040 M15
190314

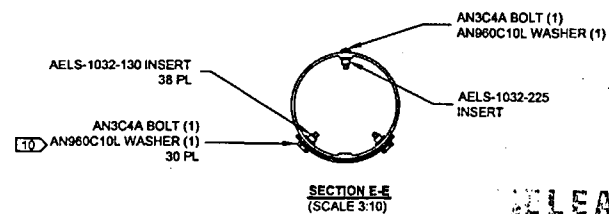
D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	UP	DRAWING NO.	REV. D
MFG. APPR.	AS	D3507	SHEET 1 OF 2
APPROVED	ST	TITLE	SCALE
DE APPR.	ST	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3507-041 ASSEMBLY DETAIL



SECTION G-G (SCALE 3:10)



RELEASED
2013-12-13

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 2 OF 2
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DE APPR.	JP	EC 135 SKIDTUBE	NTS
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